



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2616-1
Job Sheet 189844



Part No: D2616-1

Job Qty: 20 ea

Part Name: Mounting Lug, EC120 Step



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/31/19

Job Tracking No:

Due Date: 2/27/19

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG D2616-1 REV:E IPP REV:D (REPROGRAMMED FOR HAAS 5) 18.08.09 RQ VERIFIED BY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	2/27/19	2/27/19	0.00	0.00	Start Up Machining-1		19-03-06
100	Bandsaw	20 pcs	2/27/19	2/27/19	0.00	0.01	Bandsaw1		19-03-06
110	CNC Vertical Machining	20 pcs	2/27/19	2/27/19	0.00	11.43	HAAS 5 Axis		19-03-08
130	QC	20 pcs	2/27/19	2/27/19	0.00	0.00	QC8 Machining-1		19-03-011
140	HandFinish	20 pcs	2/27/19	2/27/19	0.00	0.70	HandFinish1		19-03-15
150	Powdercoat	20 pcs	2/27/19	2/27/19	0.00	0.29	Powdercoat3		19-03-12
160	QC	20 pcs	2/27/19	2/27/19	0.00	0.00	QC3		5 MAR 13 2019
170	Small Fab	20 pcs	2/27/19	2/27/19	0.00	1.54	Small Fab-2		9-89
180	QC	20 pcs	2/27/19	2/27/19	0.00	0.00	QC5		9-89
190	Packaging	20 pcs	2/27/19	2/27/19	0.00	0.00	Packaging3-1		MAR 13 2019
200	QC21-SA	20 Ea	2/27/19	2/27/19	0.00	0.00	QC21		MAR 13 2019

Part Op 100 - Cut blanks at 2.25"

Descriptions: 110 - 1-Machine as per folio FB477 & DWG D2616. 2- Deburr.

130 - QC8- Inspect parts - second check

140 - Chemical Conversion Coat per QSI005 4.1

150 - Grey Sandtex (Ref:4.3.5.6) per QSI005 4.3 Note: Mask large hole START TIME: 8:10 OVEN

TEMPERATURE: 320 FINISH TIME: 8:40

160 - QC3- Inspect Part Finish

170 - 1-Coat bearing in light oil 2-Press Bearing in D2616-1 3-Stake as per Dwg D2616 using DT8019 4- Touch up paint if required

180 - QC5- Inspect part completeness to step on W/O

190 - Identify as per dwg & Stock Location:

200 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2611	Bearing	20 pcs (1 ea)	Small Fab	5150120
M6061T6B2.500X01.250	6061-T6 Bar 2.50 X 1.25	3.7500 ft (.1875 ea)	90-Start up Operation	5084789

5156614

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2611	20	12	0
	M6061T6B2.500X01.250	4	0	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Fwd Mounting Lug	17.000Degrees ± 0.500	17.500 16.500		17°
2	Fwd Mounting Lug	2.000inches ± 0.010	2.010 1.990		2.001
3	Fwd Mounting Lug	0.622inches ± 0.010	0.632 0.612		.623
4	Fwd Mounting Lug	0.511inches ± 0.010	0.521 0.501		.511
5	Fwd Mounting Lug	0.313inches ± 0.010	0.323 0.303		.314
6	Fwd Mounting Lug	1.000inches ± 0.010	1.010 0.990		1.001
7	Fwd Mounting Lug	1.125inches ± 0.010	1.135 1.115		1.125
8	Fwd Mounting Lug	0.250inches ± 0.010	0.260 0.240		.248
9	Fwd Mounting Lug	1.250inches ± 0.010	1.260 1.240		1.250
10	Fwd Mounting Lug	0.375inches ± 0.010	0.385 0.365		.370
11	Fwd Mounting Lug	0.625inches ± 0.010	0.635 0.615		.622
12	Fwd Mounting Lug	1.259inches ± 0.010	1.269 1.249		1.260
13	Fwd Mounting Lug	0.625inches ± 0.010	0.635 0.615		.626
14	Fwd Mounting Lug	0.250inches ± 0.010	0.260 0.240		.250
15	Fwd Mounting Lug	0.063inches ± 0.010	0.073 0.053		.0625
16	Fwd Mounting Lug	0.257inches + 0.006 - 0.001	0.263 0.256		.258
17	Fwd Mounting Lug	0.8120inches + 0.0000 - 0.0005	0.8120 0.8115		.812

Plex 1/31/19 9:55 AM dart.lacelle.linda



Container No: S159612



Part: D2616-1

Job No: 189844

Serial No/Batch: S159612

Revision: E

Inspector:

Exp Date:

Instructions: Certificate of Conformance only

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com